Work Order ID 62596

Monday, October 04, 2010 4:06:10 PM

Item ID: D3648-041 **Accept** **Setup** **Start**

Revision ID: **Stop**

Item Name: Driveshaft Tunnel Assembly

Start Date: 10/4/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/15/2010 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** ___ **Date:** 10-10-04 **Tooling:** ___ **Date:** ___ **Run** **Start**

QC: ___ **Date:** ___ **SPC (Y/N):** ___ **Date:** ___ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3648	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100  Packaging Packaging	Pick Kit **Memo**	0.00 0.00	SB 11/08/18			2			
110  Small Fab Small Fab	Small Fab **Memo** 1-Assemble as per dwg D3648□2- Seal mating surface and all gaps as per dwg D3648 with□Proseal 700 fire wall sealant□ batch: M116573	0.00 0.00	SB 11/08/18			2			
120  QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	Sulo/l/19			2			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 62596

Monday, October 04, 2010 4:06:10 PM

Item ID: D3648-041 **Accept**

Revision ID:

Item Name: Driveshaft Tunnel Assembly

Setup Start / Stop

Start Date: 10/4/2010 **Start Qty:** 1.00

Required Date: 10/15/2010 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location:______	0.00							
Packaging	**Memo** PPP 62543	0.00				____	____	11/01/19	
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	**Memo**	0.00				____	____	11/01/19	

MF 11-01-19

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Monday, October 04, 2010 4:06:15 PM

1

Work Order ID: 62596

Parent Item: D3648-041

Parent Item Name: Driveshaft Tunnel Assembly

Start Date: 10/4/2010 **Required Date:** 10/15/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:A New Issue 07-10-03 EC verified by: DD
IPP Rev:B Ecn 1113P 08-01-22 DD verified by:EC
IPP Rev:C ECN1162 08-04-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10 WASHER	NAS1149C0363 R	Purchased	No			100 M 113887	Each	0.0000	40	80	SB 11/01/13		
AN3C3A Bolt		Purchased	No			110	Each	227.0000	40	40	SB 11/01/13		
				Location		Loc Qty		Loc Code					
				ST350		227 M 118934				75			
					111916	2							
					115159	200				5			
					115371	25							
D3649-041 Tunnel Bottom Panel Assembly		Manufactured	No			110	Each	5.0000	1	1	SB 10/01/13		
				Location		Loc Qty		Loc Code					
				ST190		5							
					52638	5				2			
D3650-041 Tunnel Top Panel Assembly		Manufactured	No			110 B 62603	Each	0.0000	1	1	(2) SB 11/01/13		
D3651-041 Aft Base Assembly		Manufactured	No			110 B 62604	Each	0.0000	1	1	SB 11/01/13		(2)

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

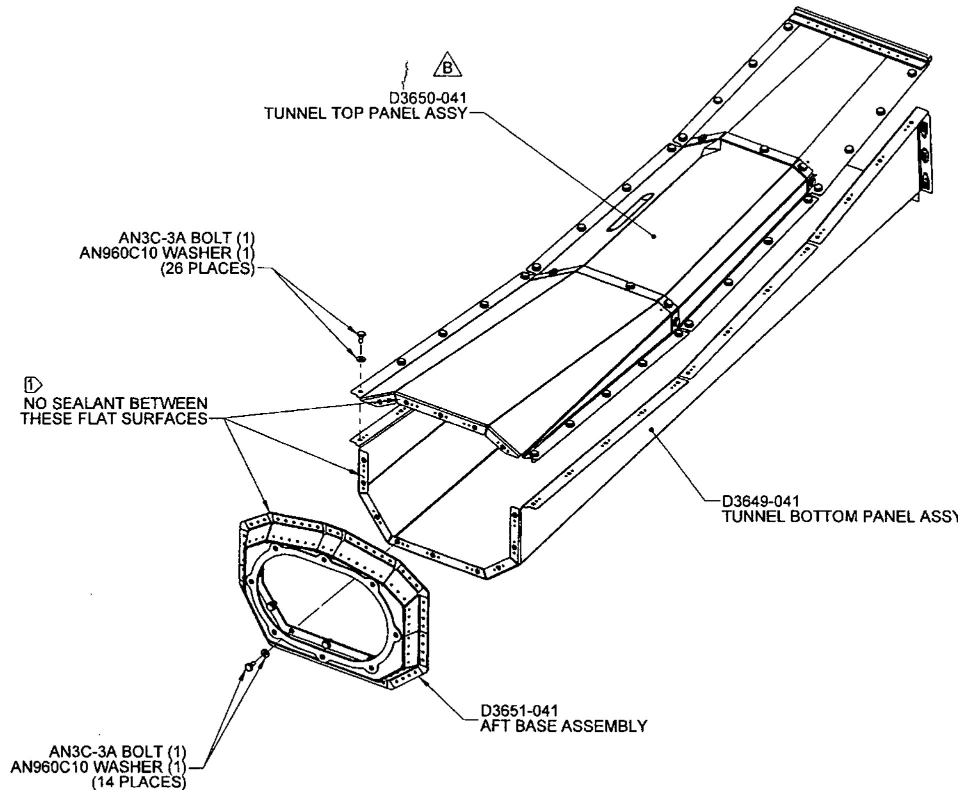
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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SHOP COPY
UNCONTROLLED
SUBJECT TO ...
WITH ...
WORK ORDER
NO. 62596
RJ 10-10-06





PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

RELEASED 08.03.27

D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY

NOTES:
1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
7) TORQUE FASTENERS TO 15-25 in-lb
8) WEIGHT: 9.2 lbs

REV.	DESCRIPTION	BY	DATE
B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D3648 — REV. B — SHEET 1 OF 1
MFG. APPR.		
APPROVED		TITLE: DRIVE SHAFT TUNNEL ASSY — SCALE 1:6
DE APPR.		
DATE	08.01.07	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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